

Date: Thursday, 6/28/2007 2:21:33 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : A119 BUBBLE WINDOW ASSY
 Job Number : 33247
 Estimate Number : 12914
 P.O. Number : NIA Part Number : D119755014
 This Issue : 6/28/2007 S.O. No. : NIA Drawing Number : D3624 Rev C
 Prsht Rev. : NC Project Number : NIA
 First Issue : NIA Type : THERMOFORMING Drawing Revision : A/C 6/28/06.28
 Previous Run : 33245 Material : NIA
 Due Date : 7/10/2007 Qty: 24
 Written By :
 Checked & Approved By :
 Comment : Est A New Issue 6/28/2007 DL

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP 119755014 CHG 001

07.07.23

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 33247A A119 BUBBLE WINDOW



Comment: Sub-Component A119 BUBBLE WINDOW

4.0 D2126 Seal



Comment: Qty.: 7.4372 f(s)/Unit Total: 37.1858 f(s)
 Seal

Batch#

B32619

5.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D119755014

Location:

PPP Rev:

Rev E

7/7/23

SP

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 BUBBLE WINDOW ASSY

Job Number: 33247

Part Number: D119755014

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



②

Comment: FINAL INSPECTION/W/O RELEASE

07/07/23

Job Completion



Kim 07-07-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

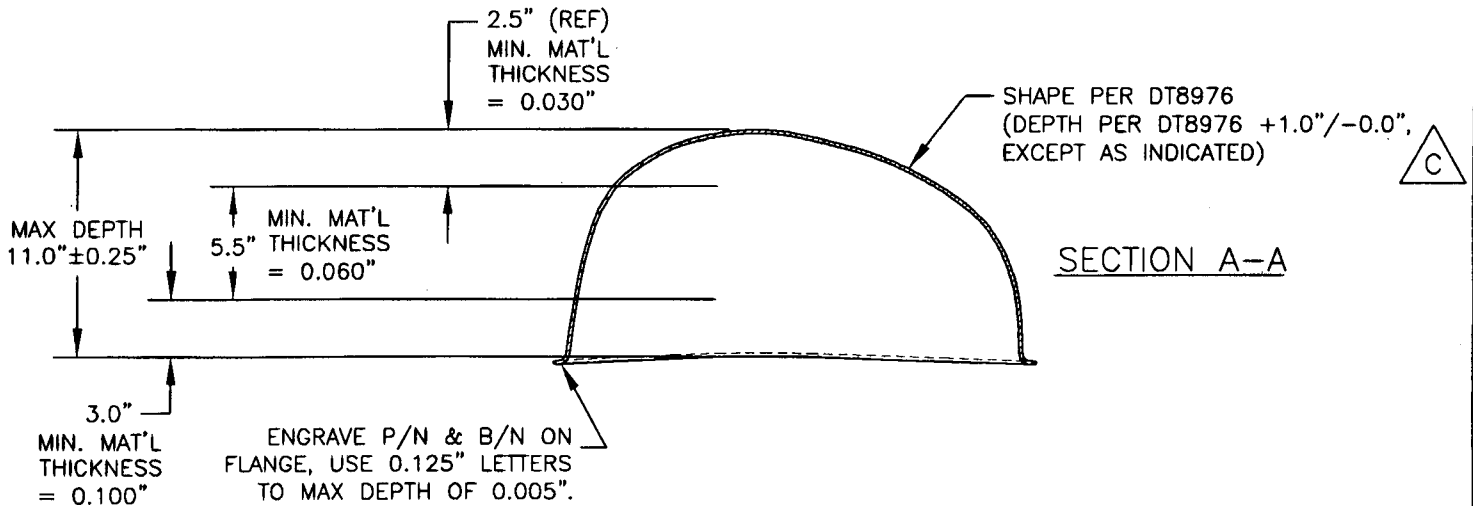
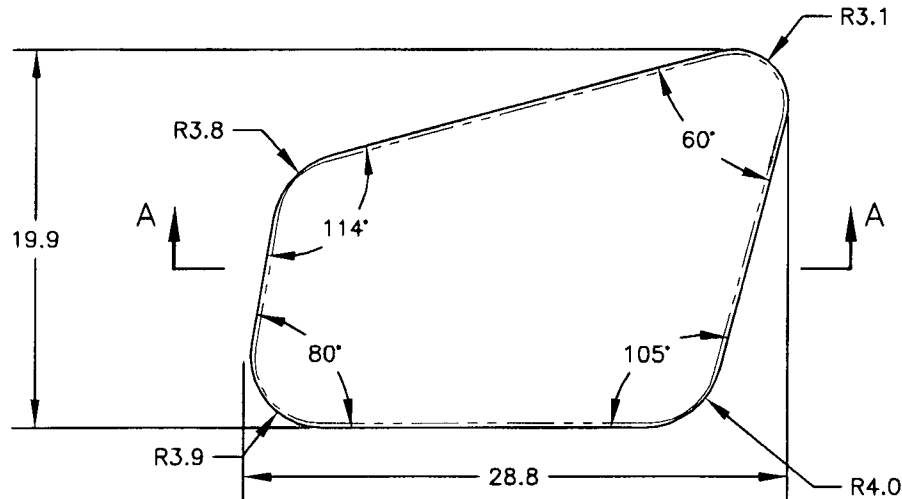
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN qp	DRAWN BY qp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3624	REV. C SHEET 1 OF 1
DATE 07.06.27		TITLE BUBBLE WINDOW (A119)	SCALE 1:10
A	07.05.14	NEW ISSUE	
B	07.05.24	11.0" DEPTH WAS 12.0"	
C	07.06.27	ADD TOOL TO CONTROL BUBBLE SHAPE	

RELEASED
07.06.28. #**D3624-2 BUBBLE WINDOW**

- MATERIAL: POLYCAST II CLEAR ACRYLIC OR PLEXIGLAS "G" CAST ACRYLIC, 0.177" THICK (REF DART SPEC. M-ACRYLIC-S.177)
- FORM PER DT8953
FORMING PROCESS:
 - DRAPE MAT'L OVER DT8953 MOLD
 - HEAT TO 286°F
 - VACUUM TO SPECIFIED HEIGHT
 - LEAVE FOR AT 2 MINUTES TO COOL
 - TRIM WINDOW PER DT8954
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. _____

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Date: Wednesday, 23/04/2008 1:14:19 PM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 33247	Customer	: Dart Helicopters Services
Estimate Number	: 12914	DWG Name	: A119 BUBBLE WINDOW ASSY
Purchase Order #	:	Part Number	: D119755014
Complete Date	: 24/07/2007 7:33:05	DWG Number	: D3624
		Rev.	: A

DUE DATE	ORDERED	DELIVERED
10/07/2007	5	5

3.0 D36242-Bubble Window SUB-Component/Sub-job

DATE	EMPLOYEE	TYPE	Qty			
23/07/2007	LACE01: Lacelle, Linda		3.000		\$1043.52	33247A

Subtotal: CTD: 3 \$1043.52

4.0 D2126-Seal INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
23/07/2007	BOUC02: Boucher, Emilie	D2126	7.500		\$26.62	Lot # 32619 Qty. 8
23/07/2007	BOUC02: Boucher, Emilie	D2126	7.500		\$26.62	Lot # 32619 Qty. 8
23/07/2007	BOUC02: Boucher, Emilie	D2126	7.500		\$26.62	Lot # 32619 Qty. 8

Subtotal: QTD: 0 CTD: 24 \$79.86

		TIME	COST	
	Machine Time:	0.00	\$0.00	
	Labor:	0.00	\$0.00	
	Sub-contract (external Op.):		\$0.00	
	INVENTORY ITEM:		\$79.86	
	SUB-COMPONENT (SUB-JOB):		\$1043.52	
Total:			\$1123.38	

COST PER UNIT: \$224.67